

Work Order ID 128064

Monday, January 05, 2015 2:18:36 PM

128064

Page 1

Item ID: D4131-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Manifold Assy

Start Date: 1/5/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/5/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 15-01-05 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4131

C

100 Weld per dwg A/R S.S. rod Batch: 1123821 0.00

100

Large Fab

Memo

0.00

Large Fab

4 EQ 15-1-7

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

④ 15-01-08 PD

PTO

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

④ 15-01-08 PD

QA Closed: 8/29/13 Date: 5/2/13



Work Order update only

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		15-01-7	100	1	scrap 1 pc welder forgot to start the gas (purge) R. operator error/ No verification before starting Jan	S 02/24/2 15/12/23	scrap / destroy the replace D4131-1 B 126830 D4131-3 B D4131-5 B (\$10.80)	EL 15-1-7	DAS 38 9-89 JAN 07 2015	DAS 9 9-89 15-01-09
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator	X									
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

124

0.00

124

Small Fab

Memo

0.00

Small Fab

ASSEMBLE LABEL PLATE AS PER DWG (D4131-045)

4x

15/01/23

DAS
36
9-89

126

QC5- Inspect part completeness to step on W/O

0.00

126

QC

Memo

0.00

Quality Control

4

DAS
38
9-89

JAN 23 2015

130

Identify as per dwg & Stock Location: 9093

0.00

130

Packaging

Memo

0.00

Packaging

4

DAS
36
9-89

JAN 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128064***128064***

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Item ID: D4131-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Manifold Assy

Start Date: 1/5/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/5/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

15/1/29

15-1-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, January 05, 2015 2:18:41 PM

Page 1

Work Order ID: 128064

128064

Parent Item: D4131-041

D4131-041

Parent Item Name: Manifold Assy

Start Date: 1/5/2015

Required Date: 1/5/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.06 new issue DD ver:EC
11.09.26 AS PER REV.B DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4131-1		Manufactured	No			100	Each	2.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4131-1

Front Plate

**

EL #15-1-5

128067 #3

Location

Loc Qty

Loc Code

ST092

2

126830

2

D4131-3		Manufactured	No			100	Each	7.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4131-3

Base

**

EL 15-1-6

Location

Loc Qty

Loc Code

ST093

7

126831

1

127188

6

D4131-5		Manufactured	No			100	Each	1.0000	2	8			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4131-5

Side Plate

**

EL #15-1-6

128068 #9

Location

Loc Qty

Loc Code

ST093

1

126333

1

D4131-9		Manufactured	No			124	Each	5.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4131-9

Label Plate

**

15/01/23
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1

75067

1

ST093

4

126833

4

3128152

(3x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 2

Work Order ID: 128064

Parent Item: D4131-041

Parent Item Name: Manifold Assy

128064

D4131-041

Start Date: 1/5/2015

Required Date: 1/5/2015

Start Qty: 4.00

Required Qty: 4.00

MS20615-3M3

Purchased

No

124

Each

2,232.000

2

8

MS20615-3M3

RIVET

**

15/01/23

DAS
36
9-89

Location

Loc Qty

Loc Code

ST307

2232

124859

2232

8

Monday, January 05, 2015 2:18:41 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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